



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.4410
Job Sheet 190681



Part No: 647.4410

Job Qty: 16 pcs

Part Name: Rail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/13/19

Job Tracking No:

Created By: Linda Lacelle

Due Date: 2/28/19

Description:

Type: SOLD

Note: DWG REV n/c SHEETS 1,2 IPP REV A RQ VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	HAAS 4 Axis	16 pcs	2/28/19		0.09	8.58	HAAS - 1	JLP 19-02-14
							HAAS - 2	
							HAAS - 3	
							HAAS - 4	
120	QC 2	16 pcs	2/28/19		0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	JLP 19/02/13
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	



Container No: S153642



Part: 647.4410

Job No: 190681

Serial No/Batch: S153642

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/14/19

				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
130	QC 8	16 pcs	2/28/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
140	Outsource - 4 - Anodize	16 pcs	2/28/19	0.00 0.00	A7C
150	Packaging 2-1 - Receive - B4B	16 pcs	2/28/19	0.00 0.00	CC190215
					Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B
					Packaging 2 - 30 - B4B
					Packaging 2 - 31 - B4B
					Packaging 2 - 32 - B4B
					Packaging 2 - 33 - B4B

19/02/19

8

MAR 08 2019

				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
155 QC 6	16 pcs	2/28/19	0.00 0.00	QC 6 - 42	
				QC 6 - 9	DAS
				QC 6 - 68	MAR 11 2019 68
				QC 6 - 61	9-89
180 Packaging 3-1 - Stock - B4B	16 pcs	2/28/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	CK081 DP MAR 11 2019
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	16 pcs	2/28/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	MAR 13 2019 70
				QC 21 - SA - 53	9-89

Part Op 110 - HAAS1-1 (HAAS CNC Vertical Machine) Cut Blank at 15.00" 1-Machine per folio FB282 DWG REV: N/C

Descriptions: FOLIO REV: N/C 2- deburr and break all sharp edges

120 - QC2 Machining-1 (QC2- Inspect parts off machine FAI/FAIB)

130 - QC8 Machining-1 (QC8- Inspect parts - second check)

140 - Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1 Issue P/O to ATG : P0042622 Black Anodize as per Dwg 647.4400 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Conformity is required

150 - Packaging2 (Receive & Inspect for Damage & Mat'l Certs)

155 - QC6 (QC6- All purchased or subcontracted products)

180 - Packaging3-1 (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

190 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
647.4400E	Rail	20 pcs (1.25 ea)	110-HAAS 4 Axis	F92576

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-HAAS 4 Axis	647.4400E	20	51	0

Part Specifications

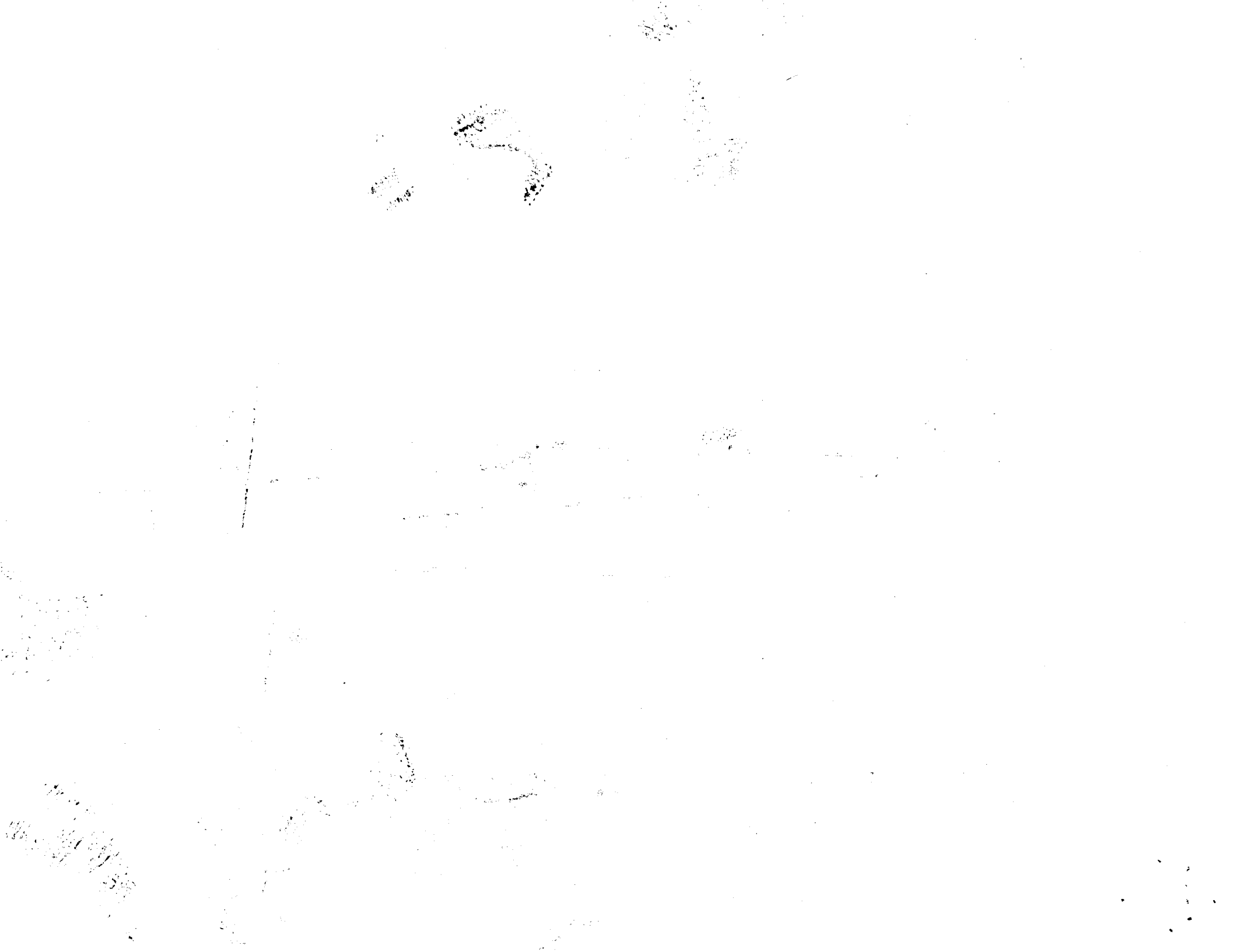
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Rail	2.000inches ± 0.010	2.010 1.990	2.00	
2	Rail	1.250inches ± 0.005	1.255 1.245	1.251	
3	Rail	0.375inches ± 0.005	0.380 0.370	0.375	
4	Rail	1.000inches ± 0.005	1.005 0.995	1.000	
5	Rail	2.000inches ± 0.005	2.005 1.995	2.000	
6	Rail	6.996inches ± 0.005	7.001 6.991	6.996	
7	Rail	12.996inches ± 0.005	13.001 12.991	12.996	
8	Rail	14.846inches ± 0.005	14.851 14.841	14.846	
9	Rail	0.438inches ± 0.005	0.443 0.433	0.438 Radius	
10	Rail	0.063inches ± 0.005	0.068 0.058	0.063 Radius	
11	Rail	0.050inches ± 0.005	0.055 0.045	0.048	
12	Rail	(0.821)inches ± 0.005	(0.816) (0.826)	0.821	
13	Rail	0.830inches ± 0.005	0.835 0.825	0.825	
14	Rail	0.340inches + 0.000 - 0.005	0.340 0.335	0.335	
15	Rail	0.900inches ± 0.010	0.910 0.890	0.902	
16	Rail	0.188inches ± 0.005	0.193 0.183	0.188	
17	Rail	0.200inches ± 0.005	0.205 0.195	0.200	
18	Rail	0.063inches ± 0.005	0.068 0.058	0.063 Radius	
19	Rail	0.125inches ± 0.005	0.130 0.120	0.125 Radius	
20	Rail	30.000Degrees ± 0.500	30.500 29.500	30° Angle	
21	Rail	14.025inches ± 0.005	14.030 14.020	14.025	
22	Rail	12.531inches ± 0.005	12.536 12.526	12.531	
23	Rail	0.692inches ± 0.005	0.697 0.687	} See attached FAT	
24	Rail	0.626inches ± 0.005	0.631 0.621		
25	Rail	0.313inches ± 0.005	0.318 0.308		
26	Rail	1.906inches ± 0.005	1.911	1.906	

			1.901	
27	Rail	2.101inches $\pm$ 0.005	2.106 2.096	2.101
28	Rail	4.201inches $\pm$ 0.005	4.206 4.196	4.201
29	Rail	6.300inches $\pm$ 0.005	6.305 6.295	6.300
30	Rail	0.201inches $\pm$ 0.005 - 0.001	0.206 0.200	Diameter 0.202
31	Rail	0.094inches $\pm$ 0.004 - 0.001	0.098 0.093	Diameter 0.093
32	Rail	1.502inches $\pm$ 0.005	1.507 1.497	1.502
33	Rail	0.813inches $\pm$ 0.005	0.818 0.808	0.813
34	Rail	60.000Degrees $\pm$ 0.500	60.500 59.500	60.0 Angle
35	Rail	23.500Degrees $\pm$ 0.500	24.000 23.000	23.5 Angle
36	Rail	41.200Degrees $\pm$ 0.500	41.700 40.700	41.2 Angle

Plex 2/13/19 10:38 AM dart.lacelle.linda

DAS
52
9-89

19/02/13





Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042622



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042622
PO Date: 2/15/19
Due Date: 2/26/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula
Phone:
Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	190501	SWA10A-700	Wire Clamp -Issue P/O to ATG: -HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 3 CLASS 2 -Certificate of Conformity is required	Firmed - X12		2/20/19	12 pcs	0 pcs	12 pcs	\$9.01/pcs	\$108.12

Line Item Note ** need asap **

2	188710	RBE703A95-0508-00-1	Quill -Issue P/O to GROUPE ALTECH: PO -ANODIZE COLOR RED, PER IAW MIL- A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE703A95- 0508-00 Rev 5C	Firmed - X11		2/20/19	11 pcs	0 pcs	11 pcs	\$8.26/pcs	\$90.86
---	--------	---------------------	---	---------------------	--	---------	--------	-------	--------	------------	---------

Line Item Note ** need asap **



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042622



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	1766034	RBT400314-7	Clamp -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A- 8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	-	2/26/19	7 pcs	0 pcs	7 pcs	\$8.26/pcs	\$57.82
4	190681	647.4410	Rail Outsource4 (Outsource process- Anodize per QSI017 4.1.10.1 Issue P/O to ATG : 1- Black Anodize as per Dwg 647.4400 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Conformity is required	Firmed	-	2/20/19	16 pcs	0 pcs	16 pcs	\$14.06/pcs	\$224.96
Grand Total:											\$481.76



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042622



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 2/22/19 11:00 AM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 917401

Date: 08-Mar-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 16 ea	Part: 647.4410 ✓ Rail Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied) Job: 24646	Rev: N/C	Line: 4
	PO: PO042622 ✓		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>MAR 08 2019</u> Certified Signature: <u>✓</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			

DAS
68
9-89